

Work Order ID 121843

October-03-14 9:48:06 AM

121843

Page 2

Item ID: D2432 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bearpaw 19" X 24"
 Start Date: 7/02/14 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 7/02/14 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* HAAS 1 HAAS CNC vertical machine #1	HAAS CNC VERTICAL MACHINING #1 Memo 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio and Dwg D2432 Identify as D2432F 3-Deburr	0.00 0.00				<i>mk/p</i> 14/10/25 -8			
140 *140* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				<i>mk/p</i> 14/10/25 6			
150 *150* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				<i>(8)</i>			DAS 38 9-89 14-10-31

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: _____	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control	cut blank per file D2432								

PP 124342

8

DAS
08
9-89

OCT 31 2014

14/11/39

14-11-03

Picklist Print

Wednesday, July 02, 2014 3:36:28 PM

Page 1

Work Order ID: 121843

121843

Parent Item: D2432

D2432

Parent Item Name: Bearpaw 19" X 24"

Start Date: 7/02/14

Required Date: 7/02/14

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 12.10.17 AS PER DWG REV.H DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MUHMWB10

Purchased

No

120

sf

503.9000

3.7

30

DAS

23

9-89

14-10-16

MUHMWB10

**

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

Location

Loc Qty

Loc Code

MAT

130.6

m129293

130.6

MAT018

373.3

m128267

47

m128668

326.3

129293

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
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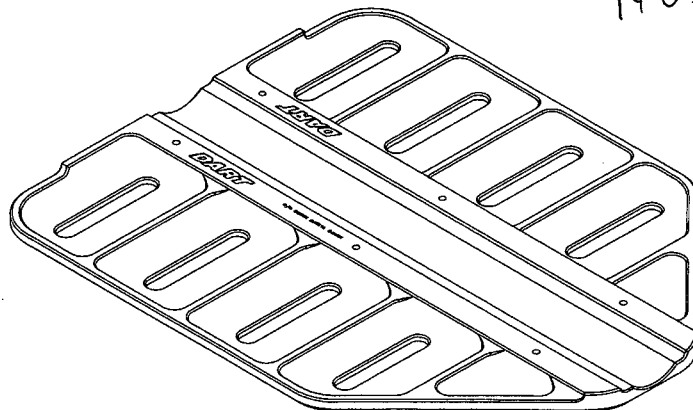
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

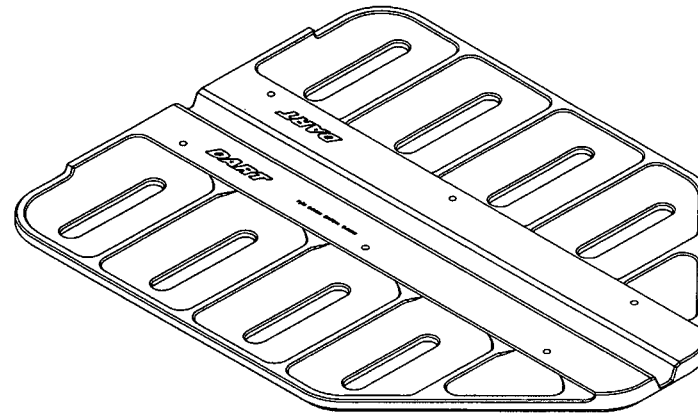
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 121843 ML5

14-07-04



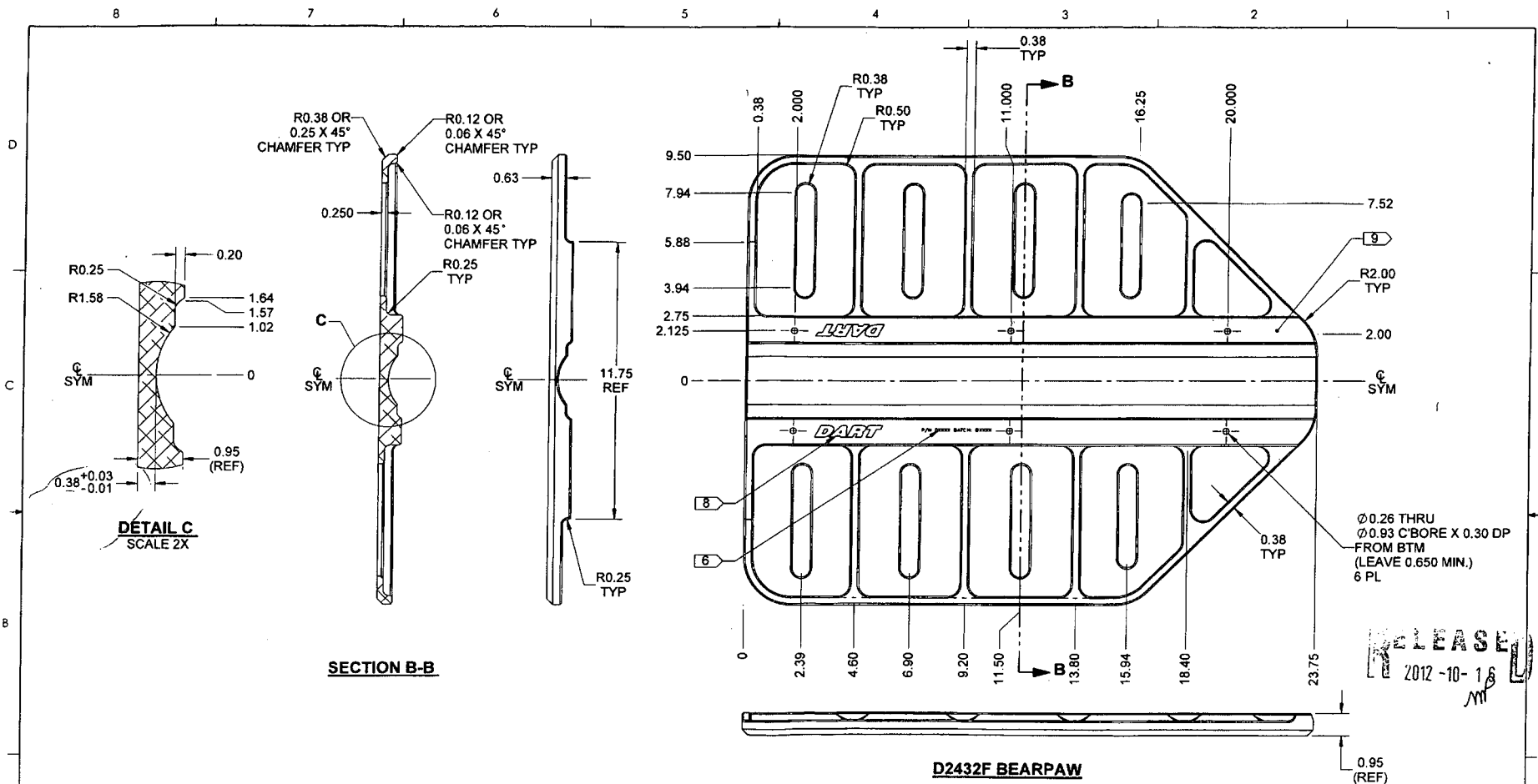
D2432F BEARPAW



D2432-3 BEARPAW

RELEASED
2012-10-16

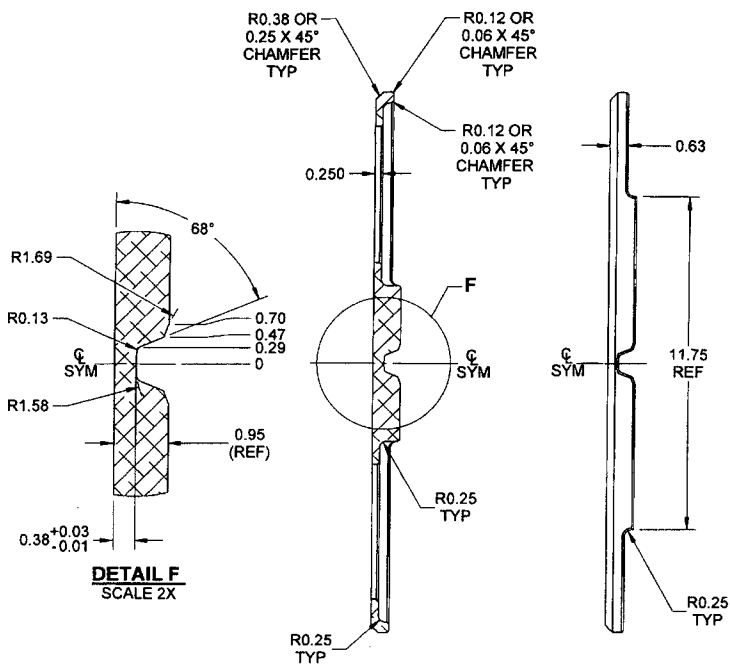
H	RIB HEIGHTS CHANGED TO CONDITION OF REV. F. SEE REV. F FOR DETAILS.	AP	12.09.24
G	UPDATE DRAWING FORMAT. REMOVED D2432B, ADD D2432-3. ADDED DIMENSION 7.52 (D1-2)	AP	12.05.02
F	CHANGE C'BORE, ADD B AND F P/N	-	98.05.12
E	CHANGE C'BORE DEPTH, BORE RADIUS	-	97.02.27
D	MOVE SLOT	-	96.06.04
C	CHANGE BORE AND C'BORE DEPTH	-	96.03.26
B	RE-DESIGN	-	96.01.24
A	NEW ISSUE	-	95.10.31
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	ASS	DRAWING NO.	REV. H
MFG. APPR.	21	D2432	SHEET 1 OF 3
APPROVED	140	TITLE	SCALE
DE APPR.	14	BEARPAW	NTS
DATE	12.09.24	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



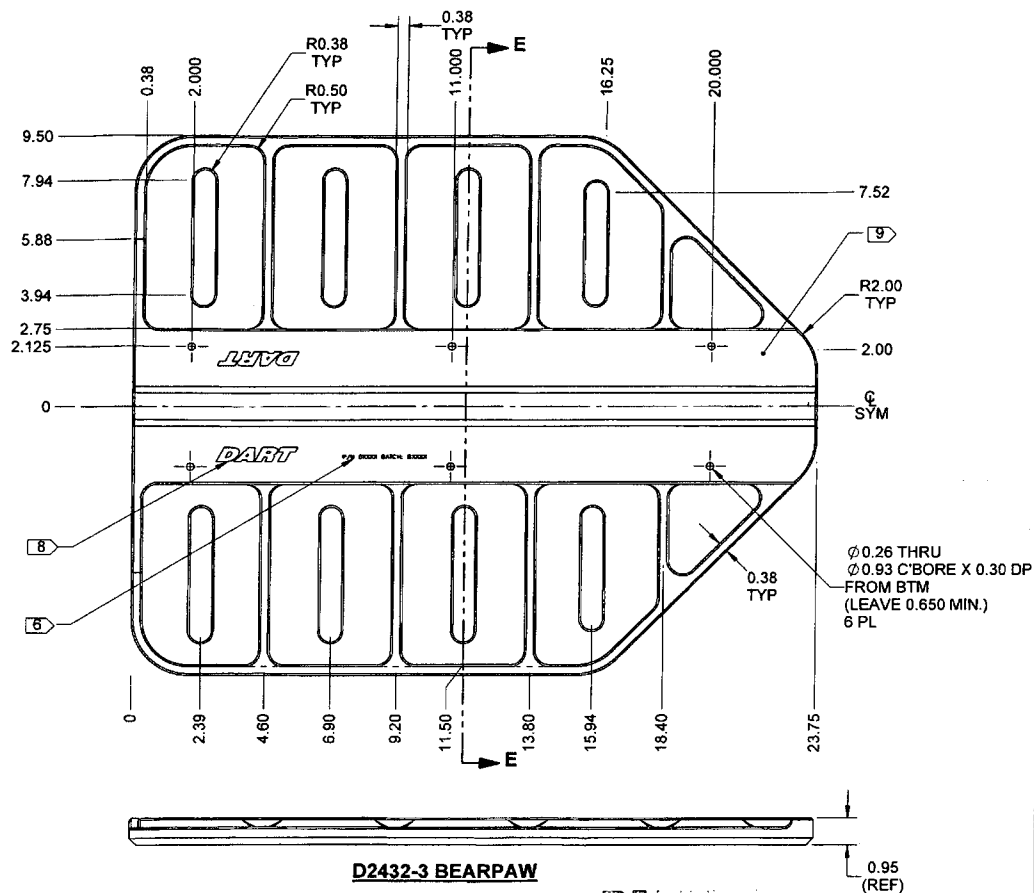
NOTES:

- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL, 1.000 THICK MACHINED TO 0.950 (REF DART SPEC. MUHMB10)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER "D2432" AND BATCH NUMBER "BXXXXX" IN ACCORDANCE WITH QSI 044 METHOD 6.3
- 7) WEIGHT: 5.87 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.012
- 9) APPLY 0.06 x 45° CHAMFER TO ALL EDGES ON SIDE SHOWN UNLESS OTHERWISE INDICATED
- 10) PROFILE PER DRAWING FILE "D2434F-REVH.STP"

DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	ASS	DRAWING NO. D2432	REV. H
MFG. APPR.	9/1		SHEET 2 OF 3
APPROVED	NO	TITLE BEARPAW	SCALE
DE APPR.	1/1		NTS
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SECTION E-E



NOTES:

- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL, 1.000 THICK MACHINED TO 0.950 (REF DART SPEC. MUHMBW10)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER "D2432-3" AND BATCH NUMBER "BXXXXX" IN ACCORDANCE WITH QSI 044 METHOD 6.3
- 7) WEIGHT: 6.25 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.012
- 9) APPLY 0.06 x 45° CHAMFER TO ALL EDGES ON SIDE SHOWN UNLESS OTHERWISE INDICATED
- 10) PROFILE PER DRAWING FILE "D2432-3-REV.H.STP"

DESIGN	LE	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. H
MFG. APPR.	2/1	D2432	SHEET 3 OF 3
APPROVED	10	TITLE	SCALE
DE APPR.	10	BEARPAW	NTS
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